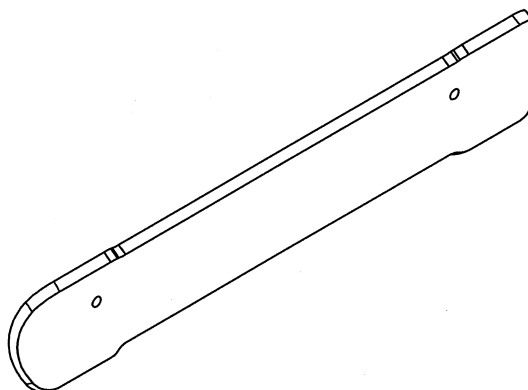
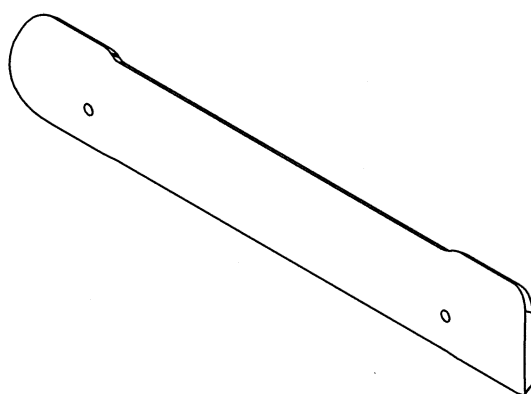


**D5520-1 DOUBLER**  
(BEND DETAIL)



**NOTES:**

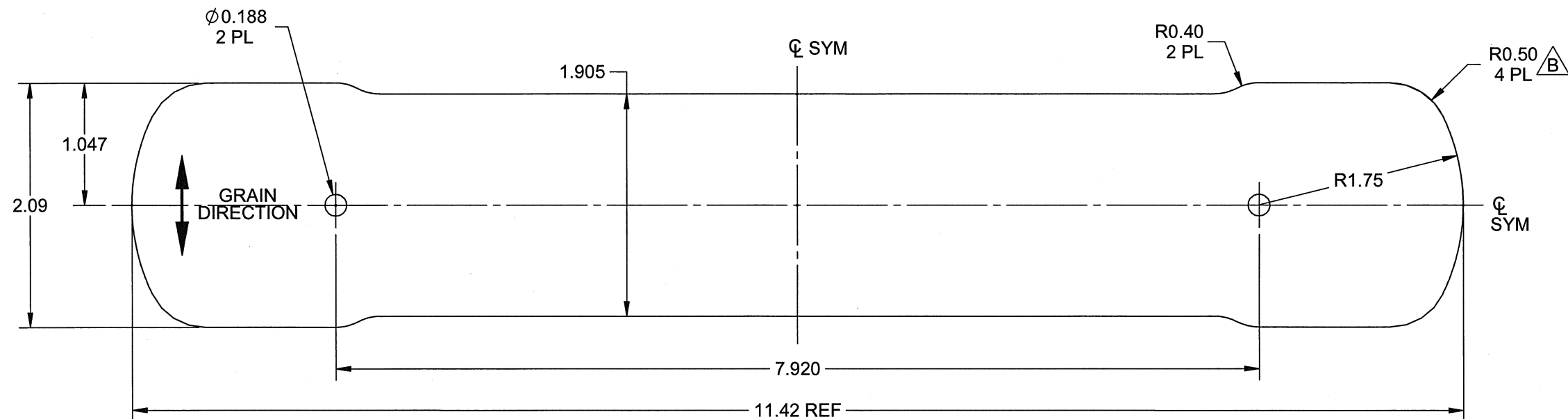
- 1) MATERIAL: MAKE FROM D5520-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

**RELEASED**

2019 SEP 10 NO  
ECN19-890

APPROVED

B	ADDED -3 FOR H145 (SHEETS 3 & 4), DELETED REFERENCE VIEW WITH RIVET HOLES AND ADDED 4 PL TO R0.50 DIM ON SHEET 2	ZF	18.11.21
A	NEW ISSUE (NCR17-6303)	ML	17.03.09
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	<b>DART AEROSPACE USA, INC.</b> HILLSBORO, OR	
DRAWN	MW		
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	<b>D5520</b>	SHEET 1 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	<b>DOUBLER</b>	NTS
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**D5520-1F DOUBLER**  
(FLAT PATTERN)

**NOTES:**

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR/SHEET, 0.188 THICK  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221 OR QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF. DART SPEC. M6061T6B0.188 OR M6061T6S0.188

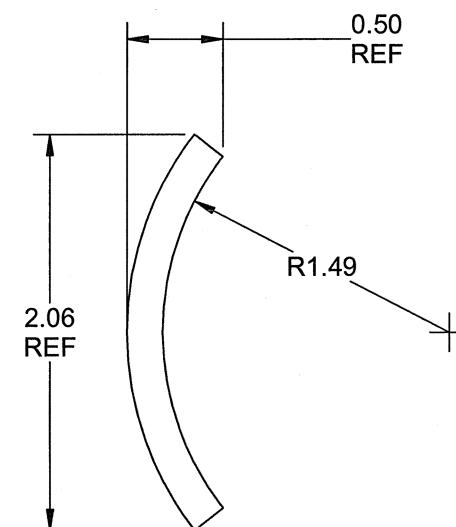
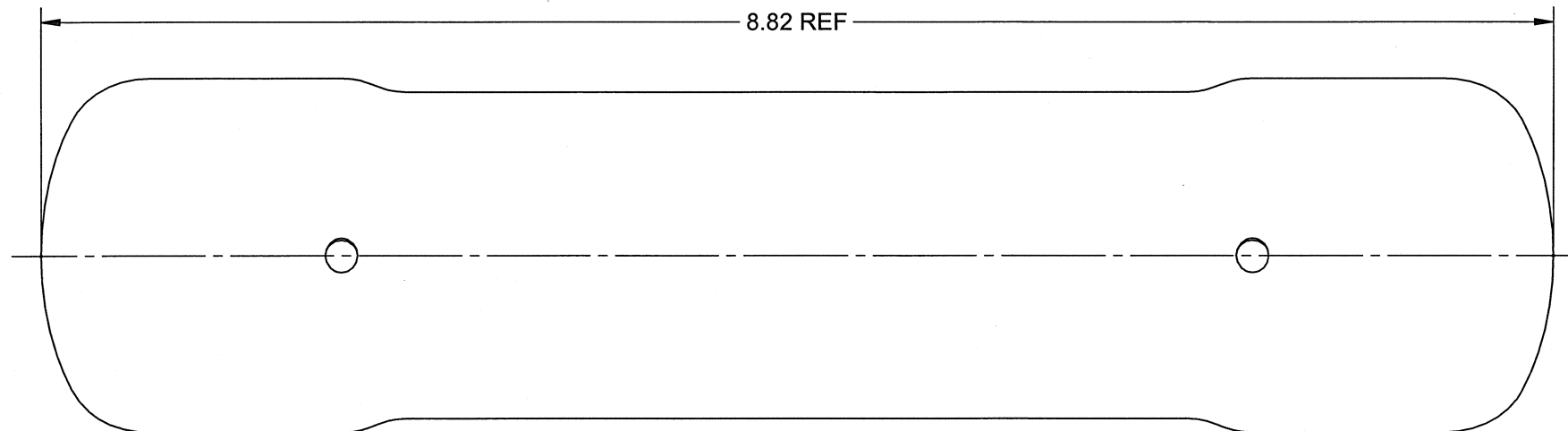
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.40 lbs

**RELEASED**

2019 SEP 10 *ND*

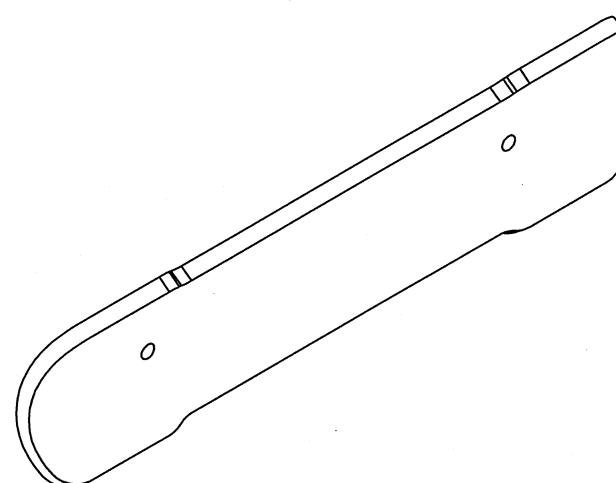
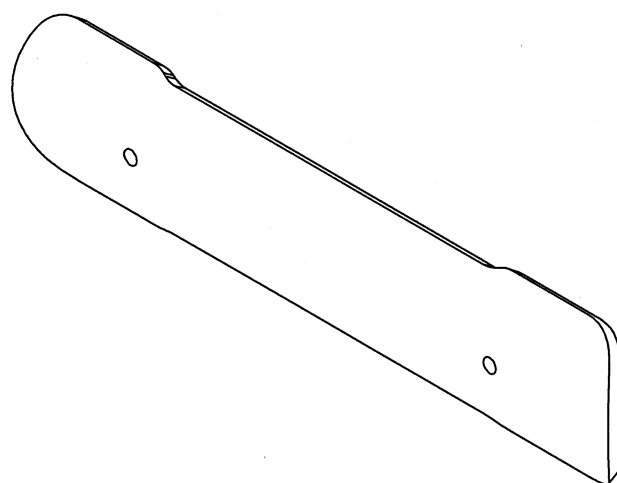
APPROVED

DESIGN	ML	<b>DART AEROSPACE USA, INC.</b> HILLSBORO, OR	
DRAWN	MW		
CHECKED	ZF	DRAWING NO. <b>D5520</b>	REV. B
MFG. APPR.	DD		SHEET 2 OF 4
APPROVED	NO	TITLE <b>DOUBLER</b>	SCALE
DE APPR.	DS		NTS
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**B**

**D5520-3 DOUBLER**  
(BEND DETAIL)



**NOTES:**

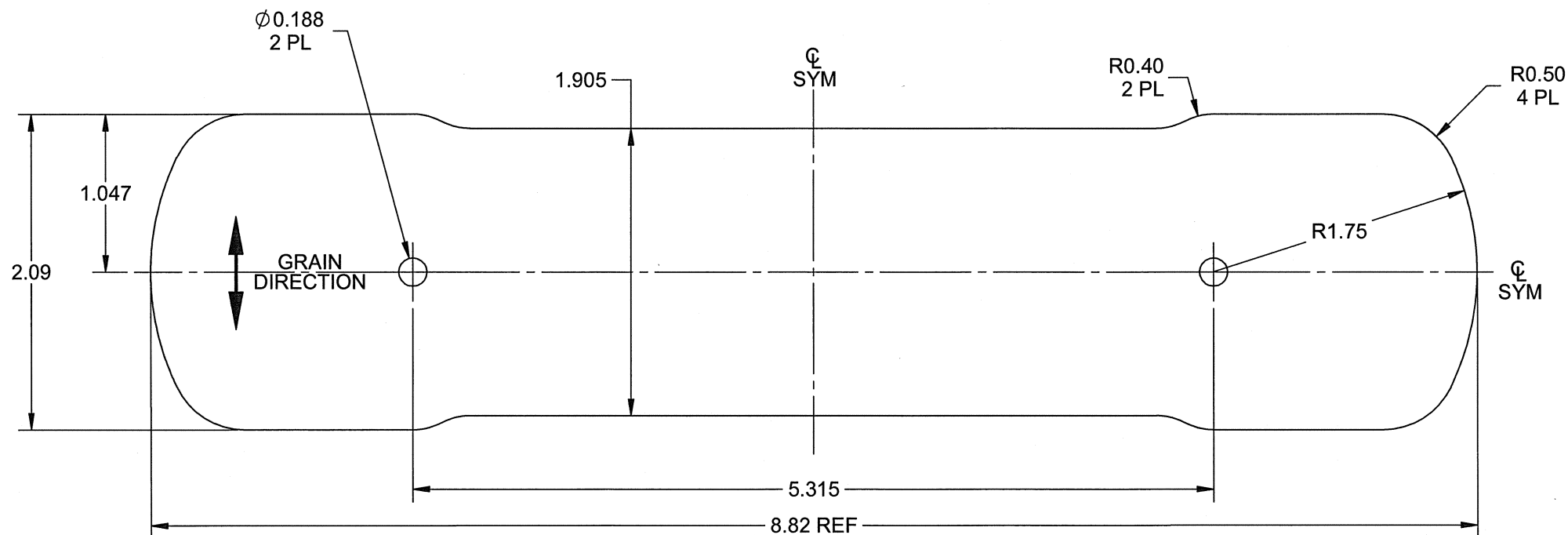
- 1) MATERIAL: MAKE FROM D5520-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

**RELEASED**

2019 SEP 10 *Wp*

**APPROVED**

DESIGN	ML	<b>DART AEROSPACE USA, INC.</b> HILLSBORO, OR	
DRAWN	MW		
CHECKED	ZF	DRAWING NO. <b>D5520</b>	REV. B
MFG. APPR.	DD	SHEET 3 OF 4	
APPROVED	NO	TITLE	SCALE
DE APPR.	DS <i>[Signature]</i>	<b>DOUBLER</b>	NTS
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**D5520-3F DOUBLER**  
(FLAT PATTERN)

**NOTES:**

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR/SHEET, 0.188 THICK  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221 OR QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF. DART SPEC. M6061T6B0.188 OR M6061T6S0.188

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.31 lbs

**RELEASED**

2019 SEP 10 *Wd*

APPROVED

DESIGN	ML	<b>DART AEROSPACE USA, INC.</b> HILLSBORO, OR	
DRAWN	MW		
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	<b>D5520</b>	SHEET 4 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	DS <i>[Signature]</i>	<b>DOUBLER</b>	NTS
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